

Work Order ID 131750

131750

Page 1

Tuesday, April 21, 2015 1:48:56 PM

Item ID: D2939-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle LH In, 206

Start Date: 4/20/15 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/20/15 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 15-04-22 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2939	Rev C

100

0.01

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.04

HAAS CNC vertical machine #1

Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

4 0 JL 15-4-30
JFC 2015-04-29

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.01

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

4 0 JL 15-4-30
JFC 2015-04-29

120

0.00

120

QC1- Inspection performed by CMM

QC

Memo

0.00

Quality Control

4 0 JL 15-4-30
JFC 2015-04-29

DAS
14
9-89 15/05/09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER :									

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Page 2

Item ID: D2939-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle LH In, 206
Start Date: 4/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				4	0		DAS 08 9-89

130

QC

Quality Control

Memo

140

Chemical Conversion Coat per QSI005 4.1

140

HandFinish

Hand Finishing

Memo

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

150

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

4 0 15-5-13 Dec

4 0 15-5-28 23 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																									

Work Order ID 131750

Tuesday, April 21, 2015 1:48:56 PM

131750

Page 3

Item ID: D2939-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle LH In, 206
Start Date: 4/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160						(4)			
QC	Memo	0.00							
Quality Control									MAY 27 2015
170	Identify as per dwg & Stock Location <u>S139S</u>	0.00				4			
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									

MAY 28 2015

MAY 28 2015

MAY 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					

Picklist Print

Tuesday, April 21, 2015 1:48:55 PM

Page 1

Work Order ID: 131750

131750

Parent Item: D2939-1

D2939-1

Parent Item Name: Saddle LH In, 206

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B00.06.26New DWG rev (mpp.2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	47.0000	1	4			

D6101-001

Saddle Billet

Location

Loc Qty

Loc Code

MAT042

40

129986

40

MAT045

7

125829

7

4 JPC 2015-04-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER :																					

DART AEROSPACE LTD	Work Order: 131750
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.129	0.128	0.127	0.125		
B	0.100	0.140		0.129	0.127	0.131	0.132		
C	0.100	0.140		0.117	0.118	0.118	120		
D	0.210	0.230		0.227	0.227	0.228	0.228		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		0.127	0.128	0.128	0.128		
O	0.540	0.560		0.546	0.545	0.546	0.545		
P	0.490	0.510		0.499	0.499	0.499	499		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		0.252	0.253	0.253	0.254		
T	0.100	0.180		0.135	0.135	0.135	0.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.317	0.317	0.317	0.317		
X	1.250	1.270		1.264	1.263	1.2645	1.264		
Y	1.565	1.585	DT8695 A/B	1.5775	1.5766	1.578	1.5775		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JFC	SK
Date: 2015-04-29	15-4-30

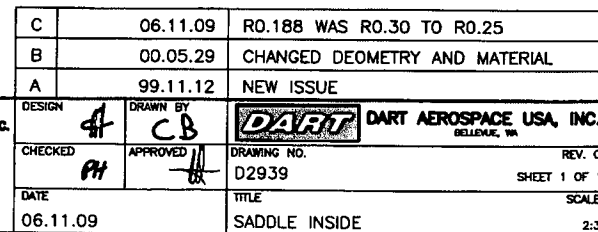
Audited by: B.A	DAS
Date: 15/04/03	08
	9-89

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



NOTES: 0.510"

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



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DART AEROSPACE USA, INC.

DART

DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO.

REV. C

02939
FILE

SHEET 1 OF 1

SADDLE INSIDE

DE 2:3



Part Number: D2939-1	Rev: C	- Page 1 -
Description: SADDLE INSIDE	Inspection Dwg: D2939	Work Order: 131750

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
A	0.120	0.020 -0.020	0.129	0.128	0.127	0.125	
B	0.120	0.020 -0.020	0.129	0.127	0.131	0.132	
C	0.120	0.020 -0.020	0.117	0.118	0.118	0.120	
D Distance YZ	0.220	0.010 -0.010	0.226	0.226	0.227	0.226	
E Distance XY	1.250	0.005 -0.005	1.250	1.250	1.250	1.250	
F Distance XY	1.250	0.005 -0.005	1.249	1.250	1.250	1.250	
G Distance XY	2.500	0.005 -0.005	2.500	2.500	2.500	2.500	
H	0.510	0.005 0.000	0.512	0.512	0.512	0.512	
I Distance XY	1.577	0.005 -0.005	1.577	1.577	1.578	1.577	
J Distance XY	2.500	0.005 -0.005	2.500	2.500	2.500	2.500	
K Diameter	0.2570	0.0050 -0.0010	0.2580	0.2574	0.2576	0.2579	
L Diameter	0.3120	0.0050 -0.0010	0.3134	0.3132	0.3135	0.3135	
M	0.235	0.005 0.000	0.239	0.239	0.239	0.239	
N Distance YZ	0.120	0.020 -0.020	0.128	0.128	0.128	0.128	
O Distance XY	0.550	0.010 -0.010	0.546	0.546	0.545	0.545	
P Distance XY	0.500	0.010 -0.010	0.499	0.499	0.497	0.501	
Q Distance XY	3.720	0.005 -0.005	3.719	3.719	3.718	3.718	
R Distance XY	2.740	0.020 -0.020	2.744	2.744	2.744	2.744	

Measured by:
Mathieu Lamarche

Date:
2015-5-9

Audited by:

Date:



Part Number: D2939-1	Rev: C	- Page 2 -
Description: SADDLE INSIDE	Inspection Dwg: D2939	Work Order: 131750

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
S	0.255	0.015 -0.015	0.252	0.253	0.253	0.254	
T	0.140	0.040 -0.040	0.135	0.135	0.135	0.135	
U Distance XY	1.630	0.005 -0.005	1.630	1.630	1.630	1.630	
V Distance XY	1.367	0.005 -0.005	1.368	1.368	1.367	1.367	
W Diameter	0.3160	0.0050 -0.0010	0.3160	0.3161	0.3150	0.3154	
X	1.260	0.010 -0.010	1.264	1.263	1.265	1.264	
Y	1.575	0.010 -0.010	1.578	1.577	1.578	1.578	
Z Radius	0.188	0.010 -0.010	0.192	0.193	0.193	0.194	

Measured by:
Mathieu Lamarche

Date:
2015-5-9

Audited by:

Date: